Date:

Tuesday, 4/4/2006 1:27:24 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 26495

Estimate Number

: 10196

P.O. Number

:N/A

This Issue

: 4/4/2006

: NC

: NIA

: 26028

Type

: MACHINED PARTS

Part Number

Drawing Number

Drawing Name

: D21751 : D2175 REV. D.,

Project Number

: N/A

: ANGLE

Drawing Revision

:NIA Material **Due Date** : 4/28/2006

Qty:

20 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

S.O. No. : N/A

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

2024-T3 .063 sheet

M2024T3S063 1.0



Comment: Qty.: 0.4958 sf(s)/Unit Total:

> Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)

9.9162 sf(s)

Batch: M/503°

06 05 09

2.0

SHEAR



Comment: SHEAR

Cut blank: 12.75" x 2.95" Grain along 2.95"

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1







Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA083 and Dwg D2175

Stack of 10

Identify as D2175-1

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK





5.0



Comment: SECOND CHECK



66-65-19

Dart Aerospace Ltd

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W /O:			WC	ORK ORDER CHANGES	3			į	
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvai QC Inspector
· · · · · · · · · · · · · · · · · · ·									
Part No	:	PAR #:	_ Fault Cate	gory:		_		1	
							l:	_ Date: _	
NCR:			ORK ORDI	ER NON-CONFORMAN	CE (NCF	R) 			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval
DATE	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector
				·					
	-								
					-				
							,		

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:27:24 PM Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: ANGLE** Part Number: D21751 Job Number: 26495 Job Number: Seq. #: **Machine Or Operation:** Description: SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 6.0 H.M 06/05/24 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack NC BRAKE 7.0 BRAKE NC Comment: NC BRAKE Form as per Dwg D2175 INSPECT WORK TO CURRENT STEP QC5 8.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING1 HAND FINISHING RESOURCE #1 9.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING 1 PACKAGING RESOURCE #1 11.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:__ <u>S1</u>220 12.0 DC DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

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Dari	Aeros	pace	Lta

Dart Ae	rospace	e Ltd							
W/O:			WORK ORDER CHANGES						
DATE	STEP	P	ROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	-								
Part No	:	PAR #:	Fault Category:	NCR: Y	es No De	QA:	Date: _		
				Q	A: N/C Clos	ed:	Date: _		
NCD:			WORK ORDER NON-COM	IFORMANCE (N	CR)				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	3	Verification Section C	Approval Chief Eng	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Approval QC Inspector		
		·								
								,		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26495
Description: Angle	Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	>	First Arti	cle	Prot	otype
Drawing	Toloronoo	Actual	Assent	Reject	Method
Dimension	Tolerance	Dimension	Accept	Kejeci	Inspect

Drawing	-	Actual		D-:4	Method of		
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Cor	nments
12.650	+/-0.010	12.652	V		Mensuring		
R0.35	+/-0.030	RO.35	$\sqrt{}$		RADISTURG	2	
2.915	+/-0.010	2,918	\checkmark		vern		
50°	+/-0.010	50°	/		Rutinctor		
0.300	+/-0.010	0.303	J		Vern		
1.050	+/-0.005	1.050			Vorn		
10.500	+/-0.005	10.502			Vein		
11.550	+/-0.005	11.550	V		Vern		
0.550	+/-0.010	0.553	V		Vein		
0.900	+/-0.010	0.906	J		URIN		
0.063 thick	+/-0.010	0063	/		Vern		
Grain Direction	N/A		V			gaz	(,
							
				•			
	•						
Measured by:		Audited by:	/_/		Prototype Ap	proval:	N/A

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 06 05 09	Date: 06-05-13	Date:	N/A

Rev	Date _	Change	_	Revised by	Approve⁄d
Α	04.08.12	New Issue		KJ/JLM	

Ŧ DOCUMENT ᇙ Copyright © 1995 by DART AEROSPACE PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM 12.650 R0.35 (TYP) GRAZN DORECTION 0.821 (TYP) 2.915 1.800 (TYP) 0.900 #0.128 (23 PLS) 0.550 -0.300 1.075 10.500 (1.050 PITCH) CHECKED 04.06.03 O œ \triangleright O 11.550 (1.050 PITCH) D2175 FLAT PATTERN 96:01.18 04.06.03 95.10.25 00.09.11 /B/ 4 1.58 R0.16 DRAWING NO. 1.500 ANGLE UNCONTROLLED COPY UPDATE FINISH CHANGED NEW ISSUE RE-DESIGN SUBJECT TO AMENDMENT WITHOUT NOTICE S NOT TO BE USED FOR A DART AEROSPACE LTD. SHOP COPY WORK ORDER RETURN TO ENGINEERING DAR1 D2175-1 BEND DETAIL SHOWN DIMENSION HAWKESBURY, (D2175-2 BENT OPPOSITE) **AEROSPAC** SPEC ONTARIO, ¥ NOTES 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSIONS ARE IN INCHES PURPOSE /c\ U SHEET 윷 COPIED SCALE 윾 ä